

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013675**Date Inspected:** 21-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 3F position for the OBG Segment 12AE at corner assembly area, weld No.CA3001J-003. The welder is identified as #050242. ZPMC QC is identified as Mr.Tang Yajun. The welding variables recorded by QC appear to comply with WPS-B-T-2133.

SMAW in the 4G position for the OBG Segment 12CE , weld No.SEG-3003A-002. The welder is identified as #066261. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4F position for the OBG Segment 12AE , weld No.SEG-3004B/C-001-143. The welder is identified as #200113. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

SMAW in the 4F position for the OBG Segment 12AE , weld No.SEG-3004A-001-063. The welder is identified as #200113. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

comply with WPS-B-P-2114-FCM-1.

FCAW in the 1G position for the OBG Segment 12AE, weld No.SEG-3001*-003. The welder is identified as #044774. ZPMC QC is identified as Mr. Zhong Guo Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F.

SAW in the 1G position for the OBG Segment 12BE, weld No.SEG-3002*-003. The welder is identified as #044771. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2C-S-2.

During random visual inspection the QA inspector observed in Traveler Rail at Bay 13 the ZPMC personnel has done Carbon Arc Gouging at both welds for UT repair. The traveler Rail is identified as 20TR2-014-011. Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Bera,Subhasis | Quality Assurance Inspector |
| Reviewed By: | Patterson,Rodney | QA Reviewer |
